

Date: Friday, 2/23/2007 1:57:03 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE  
 Job Number : 30944  
 Estimate Number : 10615  
 P.O. Number : N/A Part Number : D265623  
 This Issue : 2/23/2007 S.O. No. : N/A Drawing Number : D2656 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : D  
 Previous Run : 29336 Material : N/A  
 Due Date : 3/21/2007 Qty: 20 Um: Each  
 Written By :  
 Checked & Approved By : 07.02.26  
 Comment : Est: D, 02.10.25 Re-format KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S20GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 1:4800 sf(s)/Unit Total: 29.5995 sf(s)

1018 20 GA .040" THK

Batch: M107453 M101463 (1) SAD 07/05/27 20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2656

Dwg Rev: d

Prog Rev: a

2-Deburr if necessary

a.m SAD 07/05/27 20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/27 20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SC 07/05/27

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158

3-Identify as D2656-23

SB 07/06/21 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 27/06/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 1:57:04 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 30944

Part Number: D265623

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



~~M 10/16/01~~



Counted

Comment: INSPECT WORK TO CURRENT STEP

En 07/06/21 (x20)

7.0

POWDER COATING

POWDER COATING



M 10/16/01



(20)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

BR/M-L 07-06-21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/06/22 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(20X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

M-L 07/06/22

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/22

Job Completion



u 07-06-22

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

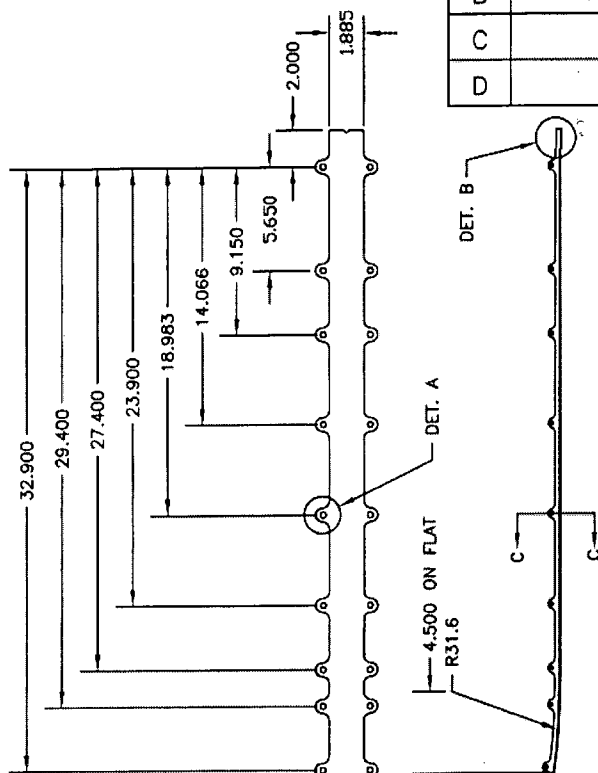
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

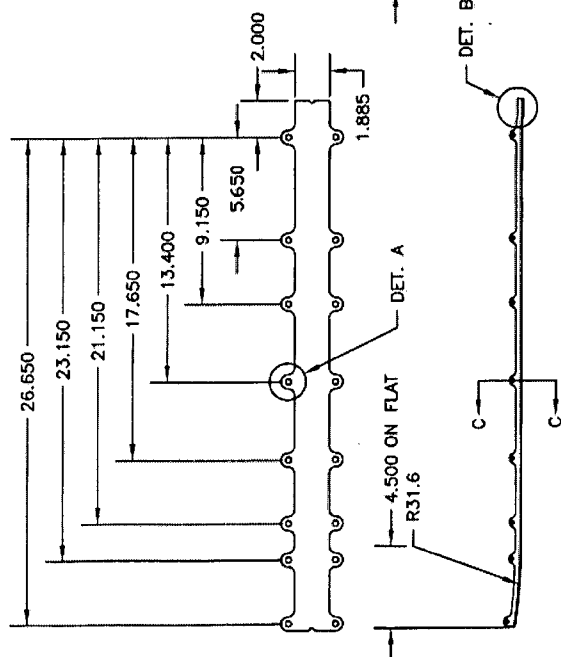


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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25	NEW ISSUE			
B	97:06:02	CHANGED TABS			
C	97:06:26	R31.6 WAS R19.5			
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT			

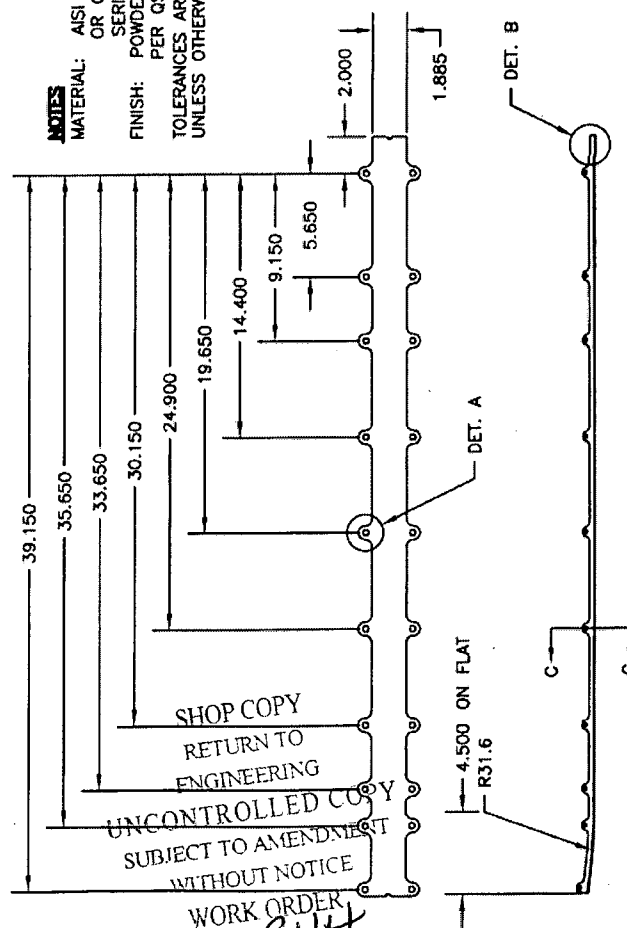
D2658-13



D2658-11



D2656-15



**NOTES**  
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
 OR CSA G40-21, 38W/44W/50W/60W/70W  
 SERIES STEEL, 20 GAUGE (0.040 THICK)  
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
 PER QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018  
 UNLESS OTHERWISE NOTED

RELEASED  
 05-09-08

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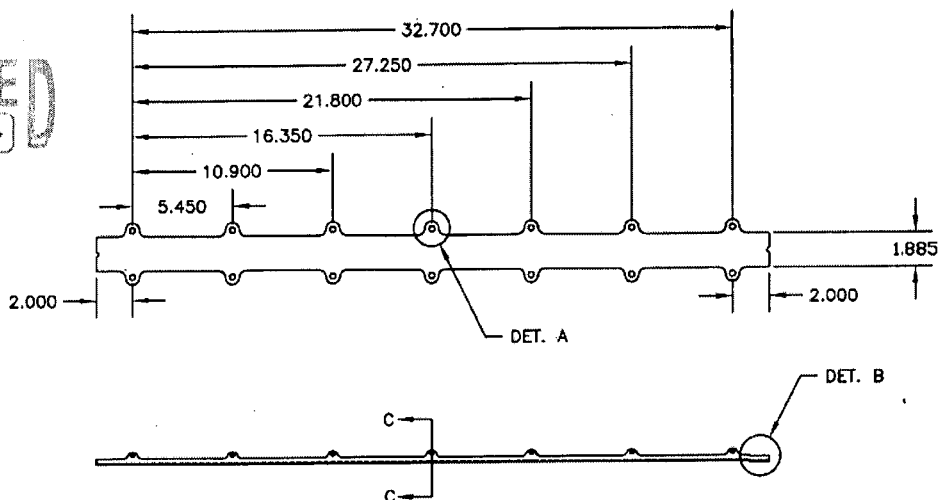
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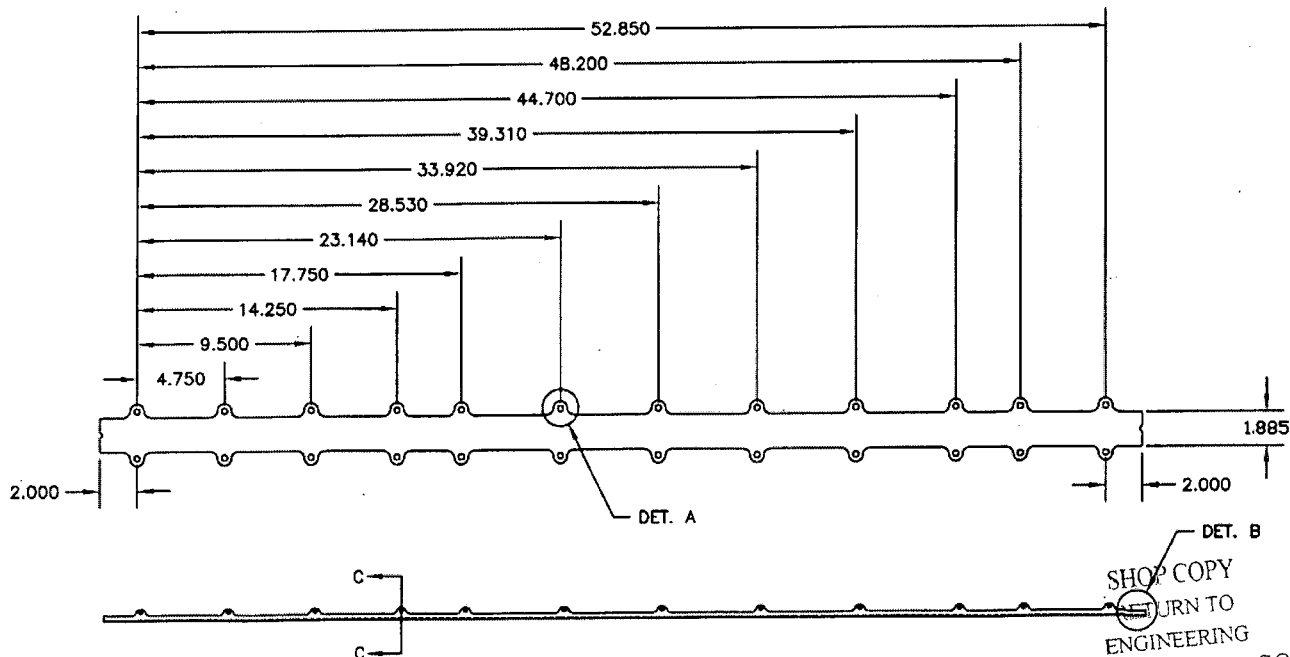
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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05.01.06 *[Signature]*

### D2656-21



### D2656-23



#### NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
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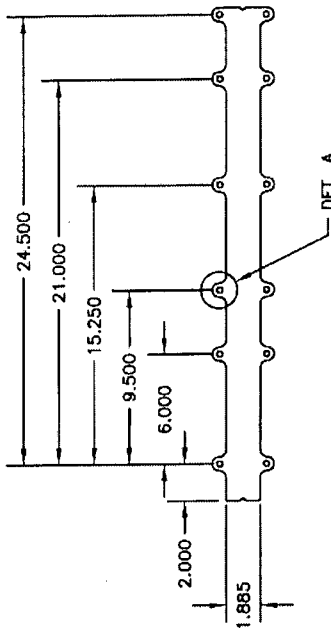
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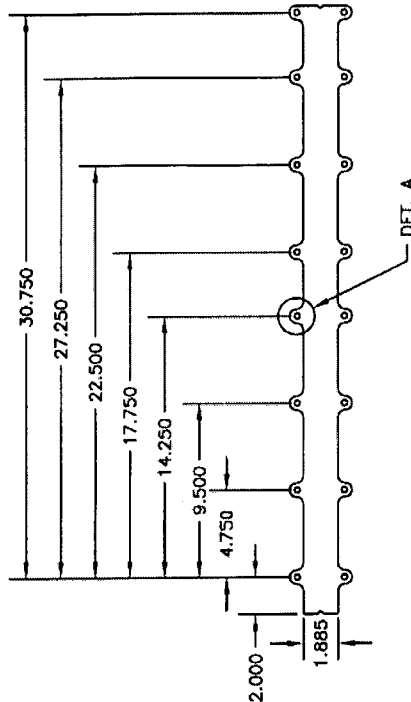


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DATE <b>05.08.17</b>		TITLE <b>WEARSHOE</b> SCALE <b>1:10</b>	

**D2656-33**

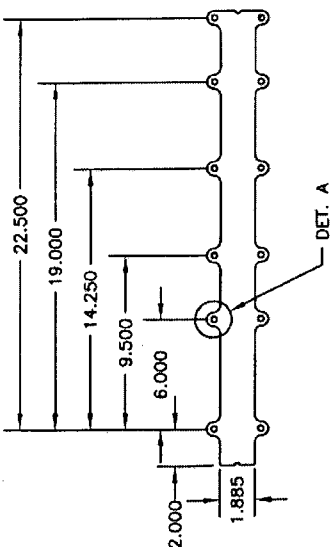


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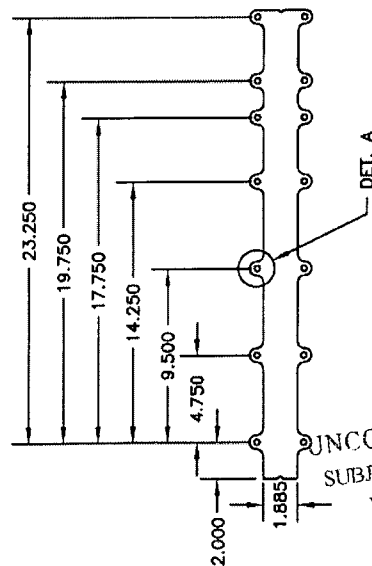


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**D2656-31**



**D2656-35**

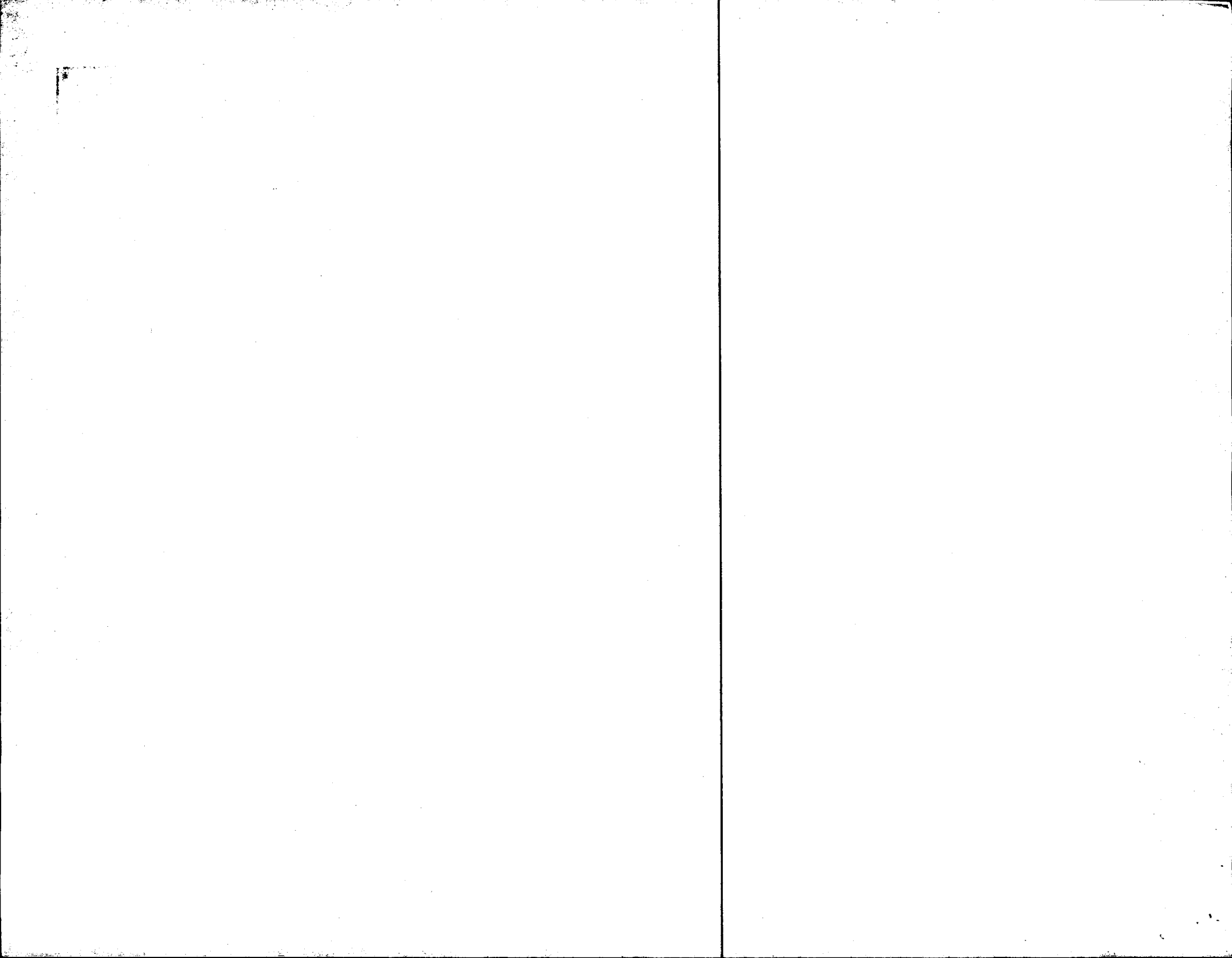


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NO. **30944**

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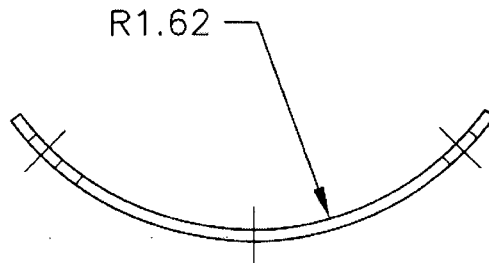






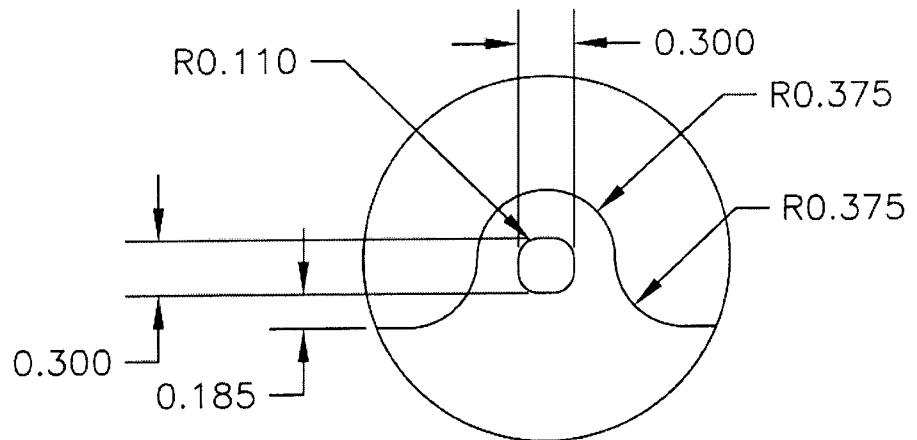
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

### SECTION C-C

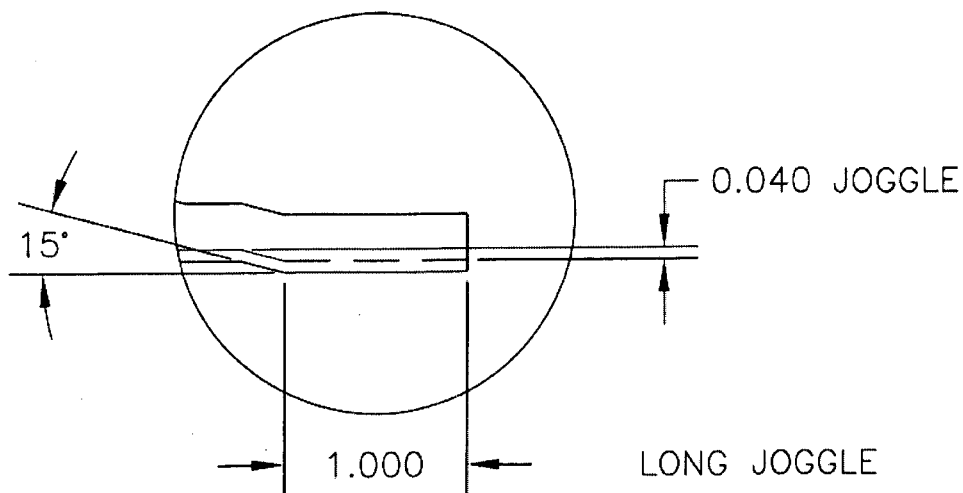


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### DETAIL A



### DETAIL B



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DART AEROSPACE LTD		Work Order: 30944
Description: WEARSHOE		Part Number: D265623
Inspection Dwg: D2656 Rev: D		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 52.850	+/- 0.010	52.850	✓		MT	
B 48.200	+/- 0.010	48.200	✓		MT	
C 44.700	+/- 0.010	44.700	✓		MT	
D 39.30	+/- 0.010	39.300	✓		M-T Vern	
E 33.920	+/- 0.010	33.920	✓		MT Vern	
F 28.530	+/- 0.010	28.530	✓		MT	
G 23.140	+/- 0.010	23.140	✓		MT	
H 17.750	+/- 0.010	17.750	✓		MT	
I 14.250	+/- 0.010	14.250	✓		MT	
J 9.500	+/- 0.010	9.500	✓		Vern	
K 4.750	+/- 0.010	4.475	✓		Vern	
L 2.000	+/- 0.010	2.000	✓		<del>light gage</del> Vern	
M 2.000	+/- 0.010	2.000	✓		<del>light gage</del> Vern	
N 1.885	+/- 0.010	1.894	✓		Vern	
O 0.300	+/- 0.010	0.300	✓		Vern	
P 0.300	+/- 0.010	0.298	✓		Vern	
Q 0.040	+/- 0.010	0.036	✓		Vern	
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <u>SM</u>	Audited by: <u>BF</u>	Prototype Approval:	N/A
Date: <u>07/05/27</u>	Date: <u>07-05-27</u>	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved

*[Handwritten signature]*

